

# Work Order ID 84014

**\*84014\***

Page 1

May-01-12 10:42:39 AM

Item ID: D3245-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 01/05/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/02 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3245

Rev B

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3245 \*\*\*\*\*prog.D3245-1/-2\*\*\*\*\* Dwg  
Rev: B Prog Rev: B 2-Deburr if necessary

3rd .035

6 Ø Jm  
12-5-14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

6 Ø Jm  
12-5-14

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

8/2/02

6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*84014\***

May-01-12 10:42:39 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 01/05/2012    **Start Qty:** 6.00    **\*6\***

**Cust Item ID:**

**Required Date:** 15/05/2012      **Req'd Qty:** 6.00      **\*6\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept  
Qty

Reject  
Qty

### Reject Number

Insp.  
Stamp

130

0.00

**\*130\***

NC BRAKE

0,00

Brake NC

## Memo

Brake NC

Deburr if necessaryC'sink as per Dwg D3245Form D3245-1 as per Dwg  
D3245Identify as D3245-1

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

## Memo

0.00

OC

## Quality Control

150

Identify as per dwg & Stock Location: GA

0.00

**\*150\***

## Memo

0.00

### Packaging

## Packaging

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR: Yes No** **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84014****\*84014\***

Page 3

May-01-12 10:42:39 AM

Item ID: D3245-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 01/05/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/7/17

MF  
12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-01-12 10:42:43 AM

Page 1

Work Order ID: 84014

\*84014\*

Parent Item: D3245-2

\*D3245-2\*

Parent Item Name: Panel

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.07.07New issueKJ/JLM  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased		No		100	sf	116.8600	0.804	5.077895			

\*M304S22GA\*

\*\*

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT020

116.86

118271

11.88

120866

104.98

120866

Jm  
12-514

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	
Description: <del>Double</del> <b>PANEL</b>		Part Number:	D3245-2
Inspection Dwg: D3245	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	✓		✓	HB-02
Ø0.375	+0.006/-0.001	0.378	✓		✓	HB-02
0.400	+/-0.010	0.406	✓		✓	HB-02
1.117	+/-0.010	1.116	✓		✓	HB-02
1.150	+/-0.010	1.143	✓		✓	HB-02
1.000	+/-0.010	0.996	✓		✓	HB-02
10.57	+/-0.030	10.563	✓		✓	HB Prod-w-02
9.500	+/-0.010	9.493	✓		✓	HB Prod-w-02
8.350	+/-0.010	8.347	✓		✓	Prod-w-02
3.500	+/-0.010	3.499	✓		✓	HB-02
9.40	+/-0.030	9.382	✓		✓	HB-02
11.04	+/-0.030	11.036	✓		✓	Prod-w-02
6.200	+/-0.010	6.194	✓		✓	HB-02
2.230	+/-0.010	2.229	✓		✓	HB-02
2.020	+/-0.010	2.023	✓		✓	HB-02

Measured by: <b>JM</b>	Audited by: <b>S</b>	Prototype Approval:	N/A	
Date: <b>12-5-17</b>	Date: <b>12/5/17</b>	Date:	N/A	
Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	<b>[Signature]</b>

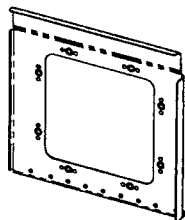
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

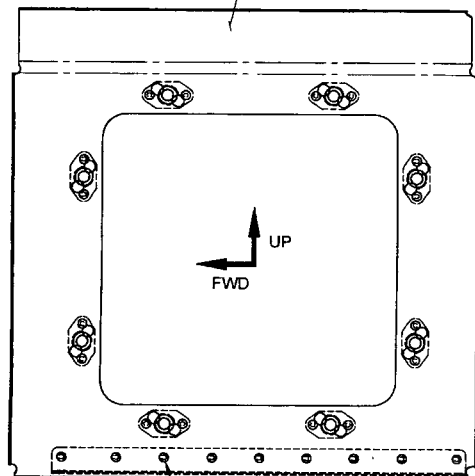
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
07-10-23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
WITHOUT NOTICE  
WORK ORDER

NO. 84014 MLJ  
12/05/02

D3245-5  
ANGLE PLATE

0.032  
GAP

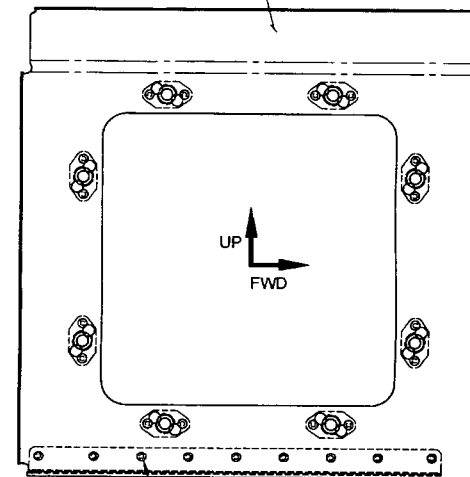
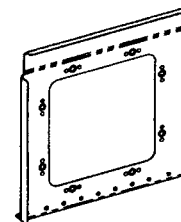
D3245-5  
ANGLE PLATE

0.032  
GAP

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)

**D3245-042 ACCESS PANEL ASSEMBLY**

B	REMOVE Ø0.204 HOLES FROM D3245-17-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3245	SHEET 1 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	ACCESS PANEL ASSEMBLY 1:2.5	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	07.10.02		

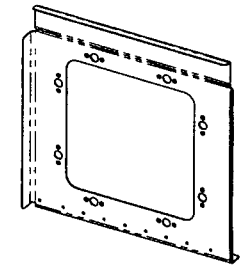
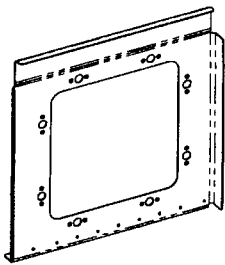
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

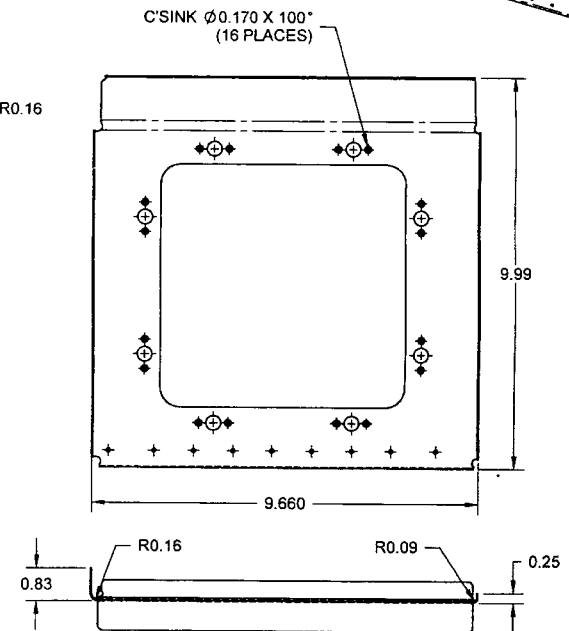
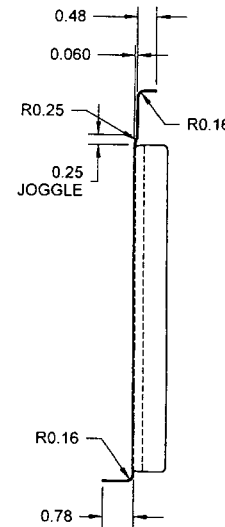
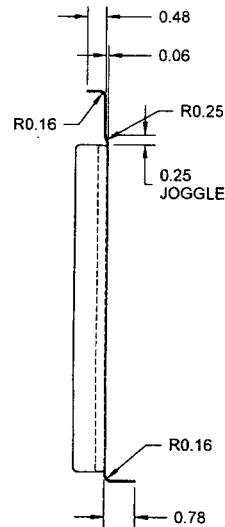
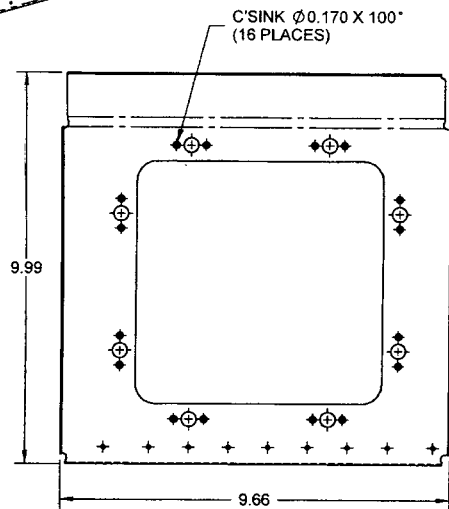
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



84014



**D3245-1 PANEL BEND DETAIL, LH**

**D3245-2 PANEL BEND DETAIL, RH**

**RELEASED**  
07.10.23

- NOTES:**
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

DESIGN	<del>7F</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>B</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	DS	D3245	SHEET 2 OF 7
APPROVED	AD	TITLE	SCALE
DE APPR.	<del>AD</del>	ACCESS PANEL ASSEMBLY	1:3
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector


Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







D3245-5 DOOR

2351-20-009-C3Y STUD (1)  
127H-35 GROMMET (1)  
(8 PLACES)D3245-7 GASKET  
(REF)8.00  
(TYP, REF)**D3245-043 DOOR ASSEMBLY**INSTALL D3245-7   
GASKET ON THIS SIDE

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3245	SHEET 3 OF 7
MFG. APPR.		TITLE	SCALE
APPROVED		ACCESS PANEL ASSEMBLY	1:2
DE APPR.		<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	07.10.02		

RELEASED  
(11/27/03)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

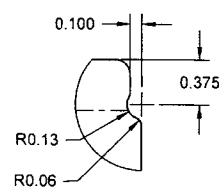
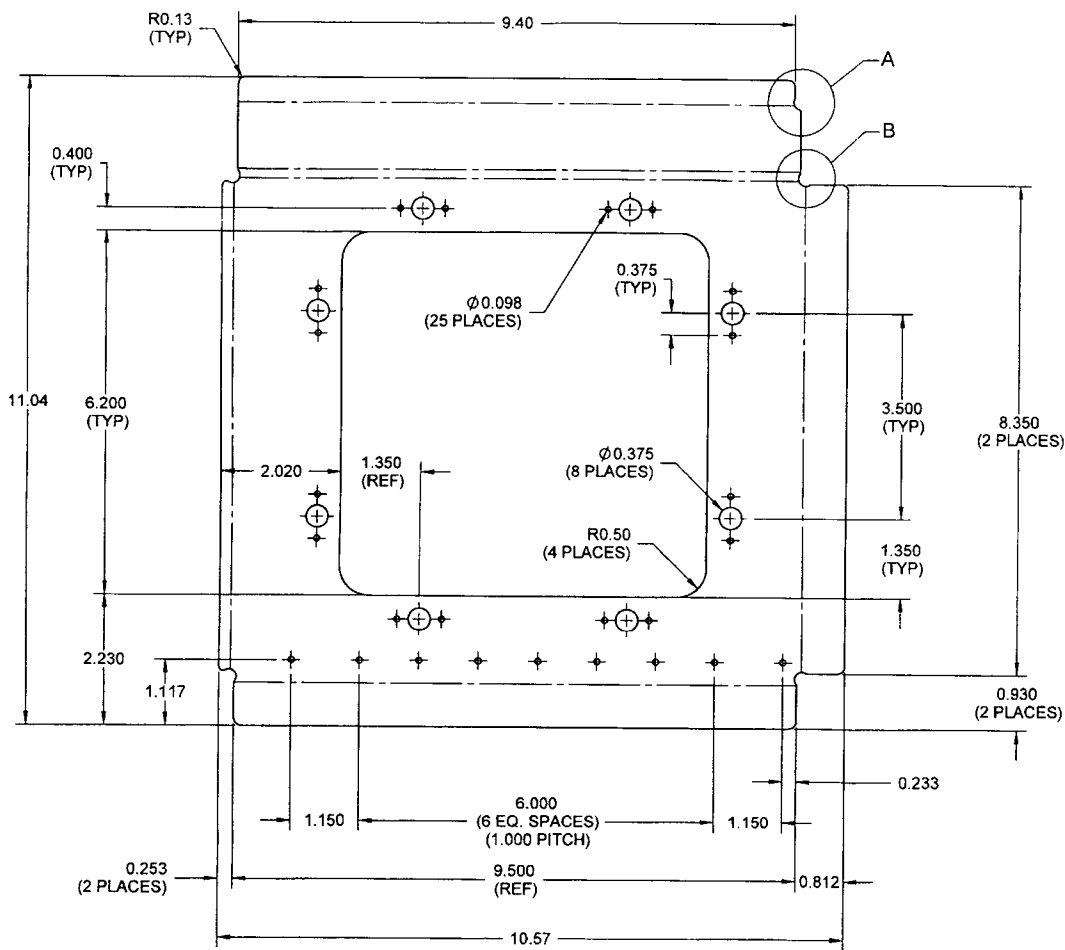
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

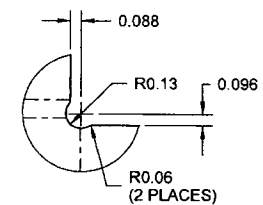
**NOTE:** Date & initial all entries



84014



**DETAIL A: RELIEF**  
SCALE 1:1



**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

RELEASED  
N/A 10-23

**D3245-1F PANEL FLAT PATTERN**

DESIGN	#	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	DS	SHEET 4 OF 7	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	<b>ACCESS PANEL ASSEMBLY</b>	1:2
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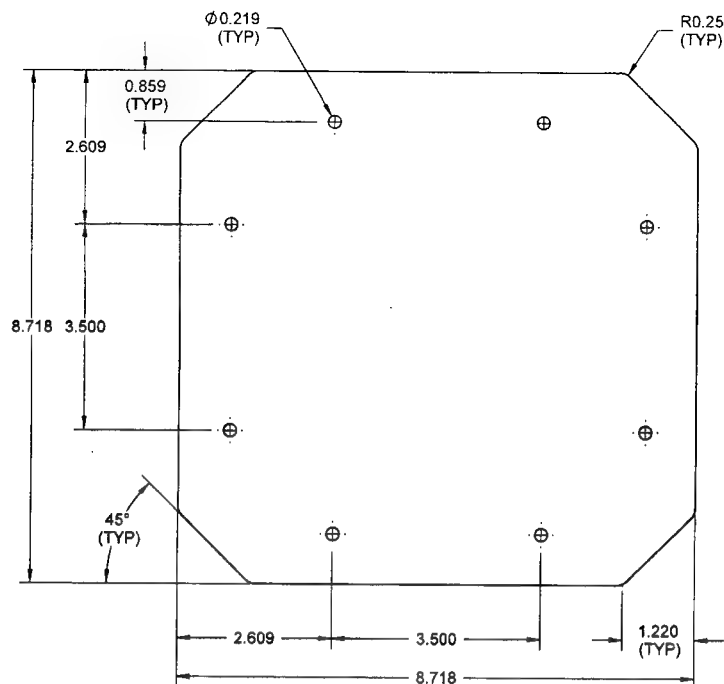
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

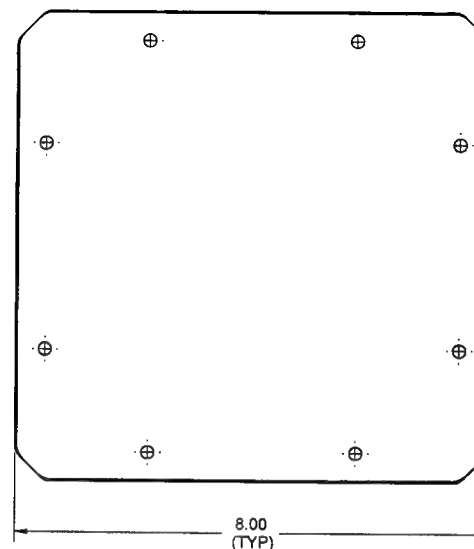
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3245-3F DOOR FLAT PATTERN**

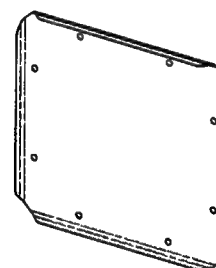


**D3245-3 DOOR BENDING DETAIL**

**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs



DESIGN	<del>PH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. E
MFG. APPR.	<del>PH</del>	<b>D3245</b>	SHEET 5 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	<b>ACCESS PANEL ASSEMBLY</b>	1:2
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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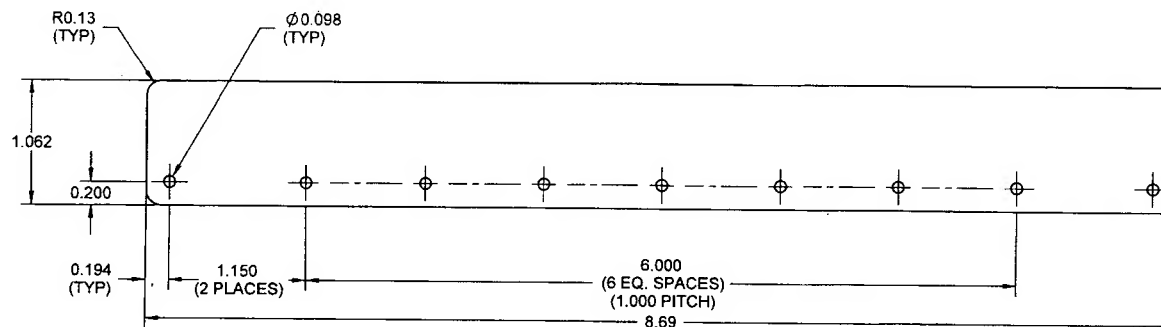
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

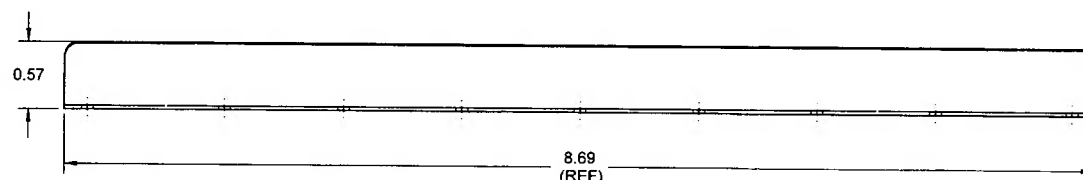
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

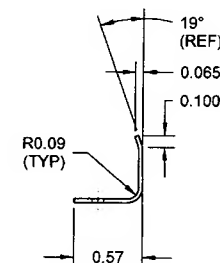
**NOTE:** Date & initial all entries



**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL  
(MAKE FROM D3245-5F)**



**RELEASED**  
07.10.02

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<del>TH</del>	<b>DART AEROSPACE LTD</b>	
DRAWN	<del>PH</del>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>PH</del>	DRAWING NO.	REV. B
MFG. APPR.	<del>PH</del>	<b>D3245</b>	SHEET 6 OF 7
APPROVED	<del>PH</del>	TITLE	SCALE
DE APPR.	<del>PH</del>	<b>ACCESS PANEL ASSEMBLY</b>	1:1
DATE	<b>07.10.02</b>	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

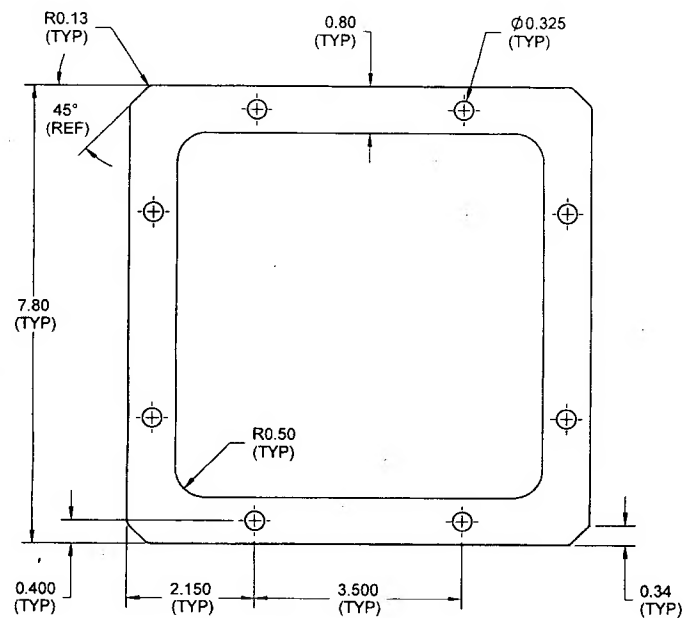
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

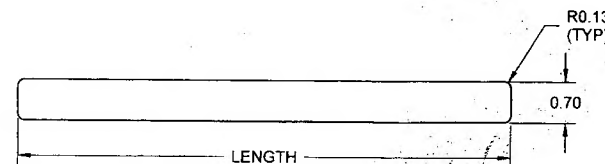
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

24014



**D3245-7 GASKET**



**D3245-X GASKET**

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

RELEASED  
07.10.02

**NOTES:**

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK  
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	7F	<b>DART AEROSPACE LTD</b>	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. <b>D3245</b>	REV. B
MFG. APPR.	PH		SHEET 7 OF 7
APPROVED	PH	TITLE <b>ACCESS PANEL ASSEMBLY</b>	SCALE 1:2
DE APPR.	PH		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries